

SB Multi Heads Series Installation Manual

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1 Check Tools

- (1) Height Gauge (1 needed include indicator)
- (2) Set the Needle bar JIG (17.7MM)
- (3) Precision Level(2/100mm, 1 Q'ty), Water Hose.
- (4) Presser Foot Level Gauge (1T)
- (5) B.D.P JIG and B.D.P Gauge.(+,- Gauge)
(+ Gauge: 0.1 / 0.2T , - Gauge: 4.3 / 4.0T)
- (6) Tester
- (7) Embroidery A/S Tool Box 1SET

2 Check the circumstances before installing

- (1) Safe arrival of the machine

Weight of SB Series machine is 3.0t (Not include Option) .

※ When moving the machine , must use the a forklift truck at least 5Ton above

- (2) Check the voltage specifications

Open the Contl box and then check the voltage specifications of embroidery (refer to pic 2)

When install the machines, Main power capacity of power consumption is 3KW(official) but recommend 5KW. If the capacity of electricity is not enough, the right operation of machines will not be possible.

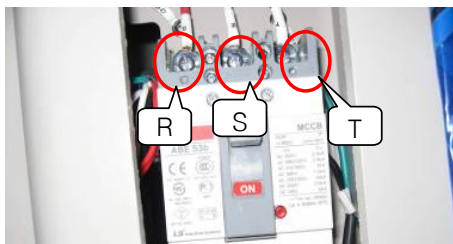
So, you must check in advance.

※ Under 3 Phase/ 5KW of power equipment , additional power build up will be needed

- (3) Check the input voltage and connect the power of machine.

After checking the Main Switch of machine is turned off Check the status of R,S,T .

(If the input voltage is different from machine voltage, adjust it by control box)



Check the all status of voltage (R,S),(S,T),(R,T).If operating voltage of the input voltage is +10% to -10% is fine.

Pic 1



If you want to change the machine voltage specifications insert it to voltage specification which you want to change the connector



Pic 2

Check the all status of voltage (R,S),(S,T),(R,T).(operating voltage of the input voltage is + 10% to -10% is fine)
If the voltage is out of the scope, inform to the factory worker for correcting the problem of voltage.

Install general AVR(Automatic Voltage Controller or UPS (Uninterruptible Power Supply)

1) Recommend to install the AVR , capacity 5KW above.

2) If the machines are too much ,which is connected to the AVR at the same time ,install the additional supplies after checking the capacity of AVR.

※ If Sequin Device is already installed, use the compressor whose capacity is above 1Mpa.



After put out the Nob , set it by turning right or left for 0.6Mpa.

(Setting errors:±0.05Mpa)

After confirming the simultaneous algebraic connected equipment,
if capacity(Mpa) is not enough, build up additional.

3 Check and Adjust of levelness.

Not for less than Y-Storke 850mm model

(1) Inspect outside of the machines and level the machine

※ When leveling by using water hose, check the air insertion in the middle of water hose, do not squeeze and walk on it.

※ Do not put the Level Guage on the square pipes or table when leveling.

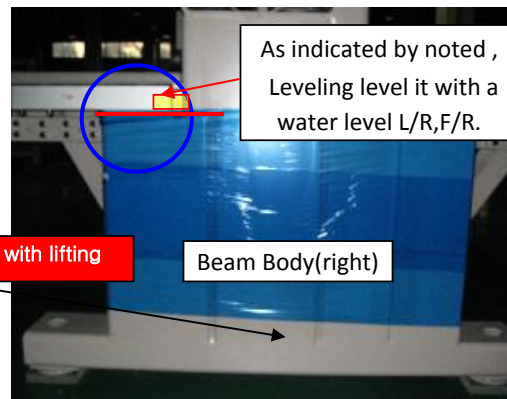
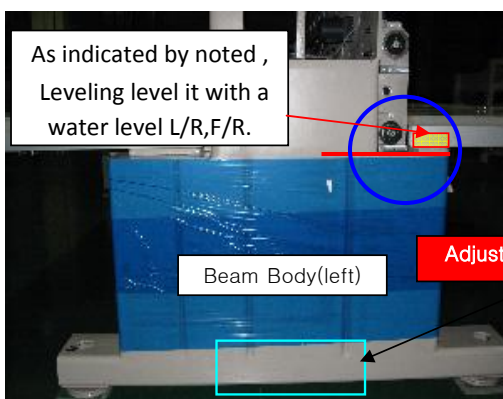
※ When leveling (L/R), check the variation of water from the hose,if it was changed, adjust it.

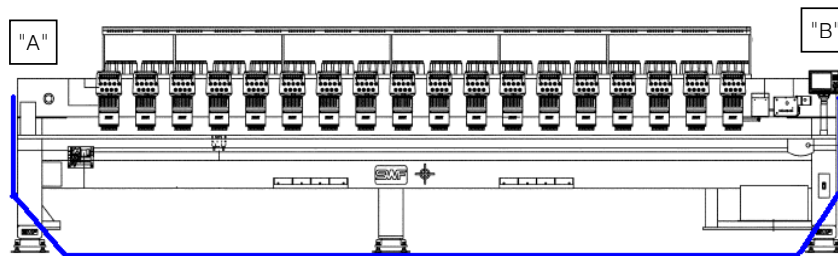
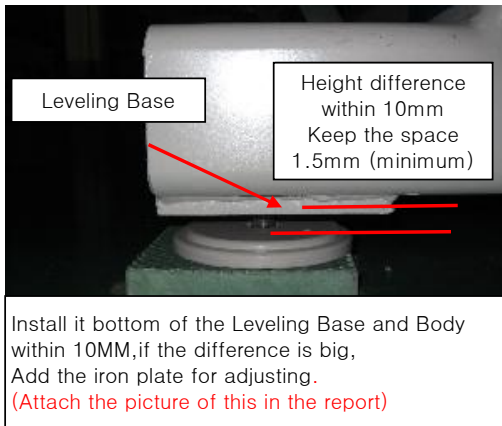
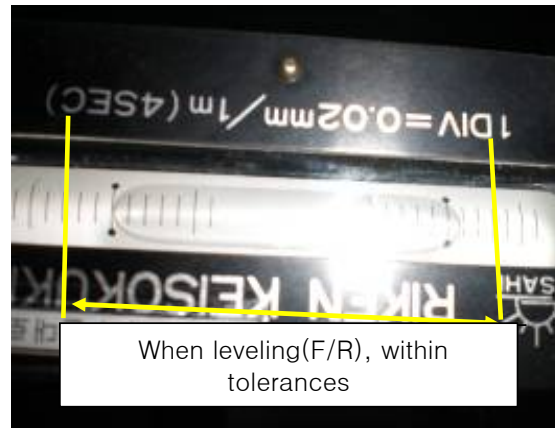
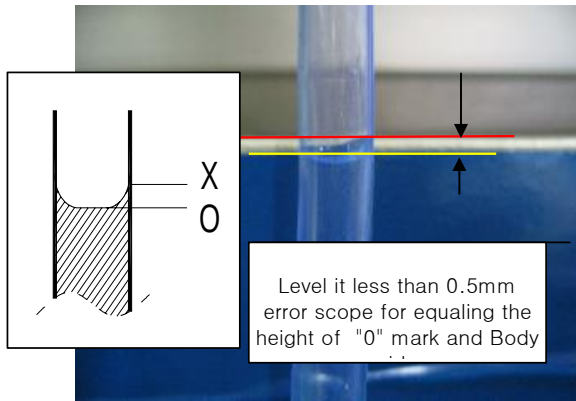
1) Levelness(L/R) : Installation must be under error scope 5mm

2) After checking that there are no debris on the base level ,install it with 2/100 error guage

(Based oh the center, left and right within three grid , left and right within 6/100 tolerances)

3) Check levelness of L/R, F/R





When leveling the water, equaling the water(inside of hose) and Body side based on "A".
If the height of water is above the Body side, put up machines with lifting tools for leveling.
If the height of water is below the Body side, place the base "A" to "B" for leveling.

4 Assembly

(1) Install Y fixed frame

Not for less than Y-Storke 1200mm model (Because it is not delivered as Fixed Frame.)



1) Don't mix the position of attaching.

2) Pre-connect Fixed Frame Plate Bolt with Y Fixed Frame Bolt and then fix the position of Y Frame Fixed Connecting Plate



Be cautious that turn aside to the left, right of Y Frame when connecting Fixing Bolt .

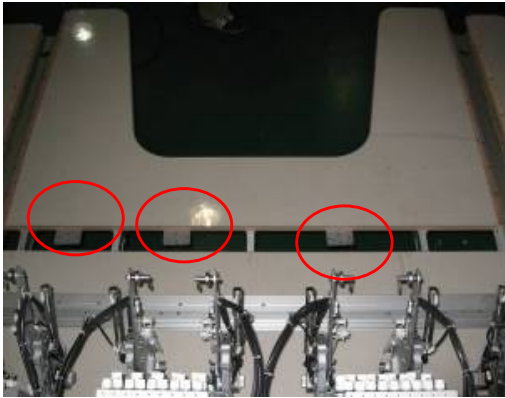
Check the declension(up/Down) and turning aside to the L/R of being fixed Y Frames with naked eyes.

In case of the table which is on the edge of front and right, assemble the Table Support, because it is separated with the Table Plate and Table Support respectively. Insert Table Supporting Connecting Bar to the Table Support which is fixed to Beam Body, and fix the Table Fixing Support Screw close by.

(2) Assemble the Table Plate

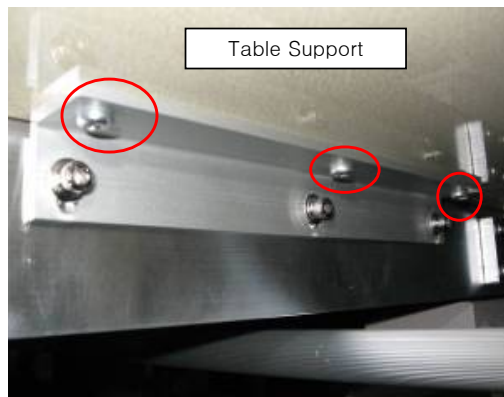
Above the Y-Storke 850mm model, assemble the plate

- 1) Refer to the sticker, assemble it in the right position.



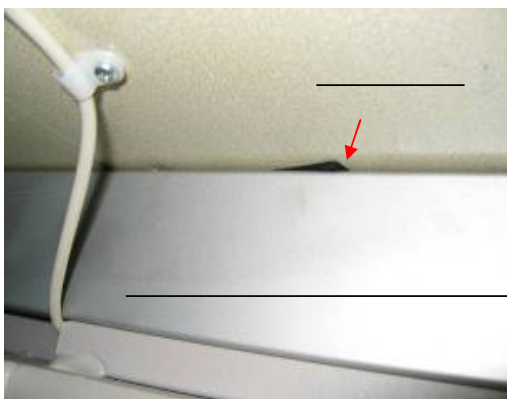
- 2) Equal to the position of Table and plate and push the plate to the Table for connecting the Table piece.
Connect the Table Support with Table Support Connecting Bolt(M10,L30) for fixing.

- 3) Connect Table Connecting Plate and Table Support with Bolt.



- 4) Check the height of Table connection and correct it.

Set correctly for showing a plane figure of table connection.(table d-party washer 0.3,0.5,0.8,1.0)

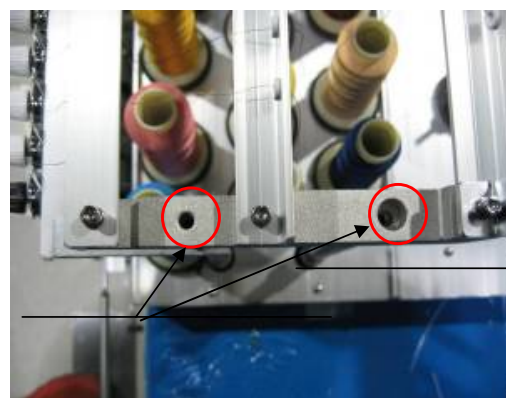


5)After assembling F/R Table ,install Table Support end Cap and Fixed Frame Rubber.



(3)How to Assemble the Spool Stand and OP BOX

1) How to Assemble Spool Stand



- ① Insert Spool Stand to Spool Stand Stud.(Insert Spool Stand "A" to Tension Plate)
- ② Fix Angle Base to Angle "D".(connect it with M4L10 Bolt)
- ③ Connect Spool Stand with Angle Set.(Insert Spool Stand to Angle Frame groove)
- ④ Fix Angle Frame Hall to Spoon Stand with Fix Bolt.(with 4mm T-Wrench)
- ⑤ Fix Spool Stand Stud Bolt to Spool Stand .(with 2.5mm L-wrench)

※ If Spool Stand/Angle and Fixed Bolt are not connected correctly, vibration from Spool Stand and Angle seems like harder than real.

2)Attach OP BOX and connect Cable.

#Not for less than Y-Storke 1200mm model (Because it is not seperated from Op.Box)



- ① Set through the Signal Cable and E-switch Cable of OP BOX to OP BOX Stand, and assemble OP BOX Stand.
- ② Wire the OP BOX Cable and Emergency switch Cable.
- ③ Attach the Table Cover. (with "+" driver)
- ④ Fix OP BOX Stand. (with 4mm T-wrench)

(4) How to assemble the Frame

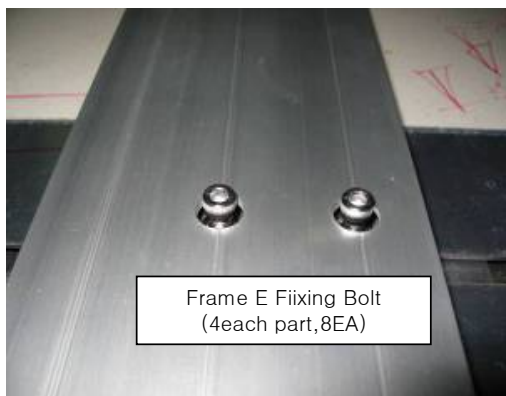
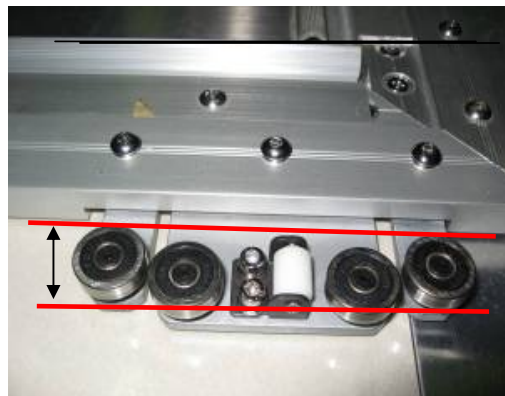
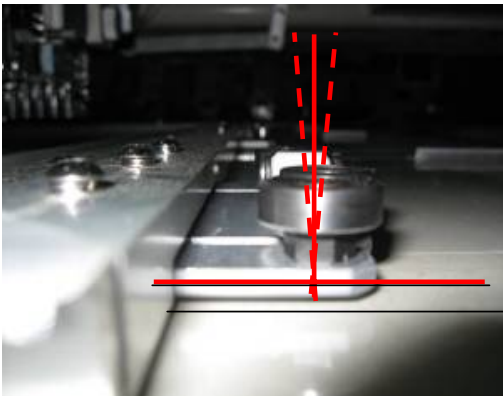
#Not for less than Y-Storke 1200mm model.

※ Move Frame toward Y direction for checking the interrupting of Frame and Frame Bearing from F/R

※ Check and adjust height of Frame Bearing and levelness.

(If levelness of Bearing is not good, when you moving it toward F/R, it can be broken by interrupting E Frame to Frame Bearing)

※ If you insert E Frame by force, it can be broken by resistance from Frame Bearing.



Frame E Fixing Bolt
(4each part, 8EA)

When connecting Frame E Fixing Bolt, pre-connect first, move Frame Up and Down and then connect it.

After connecting Frame, connect X-Shaft Coupling. (2 each) with 5mm, 3mm T-wrench.

※ If Frame E and Coupling Screw are not connected exactly, out of step and cutting will be happened.

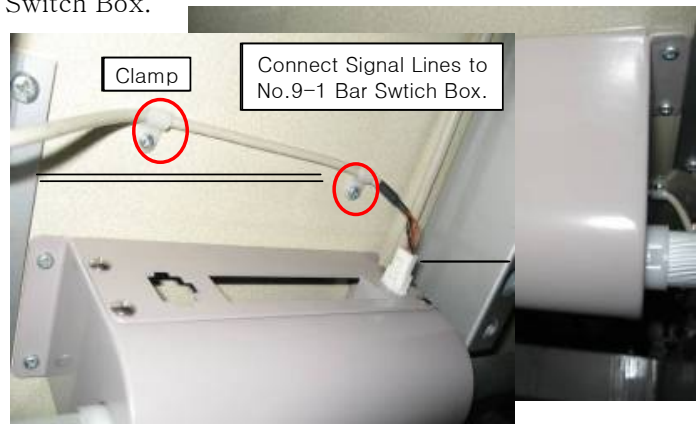
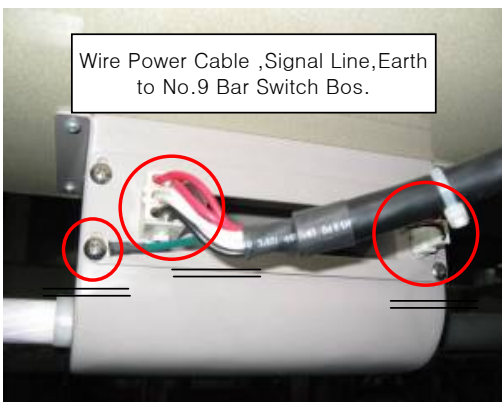
(5) How to connect Bar Switch and Cable.

For more than Y-Storke 850mm model.

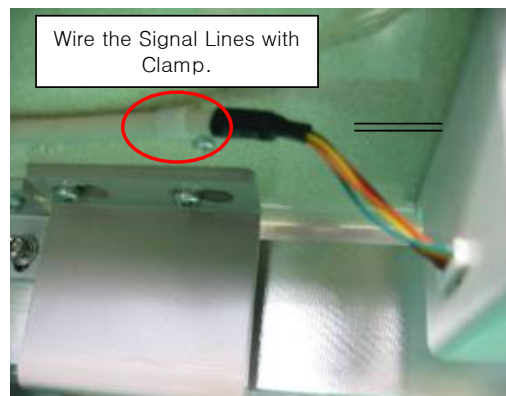
1) Connect Bar Switch Holder and Box according to the location.



2) Connect Signal lines and Power Cable to Bar Switch Box.



(6) Assemble offset Switch and wire the cables.(6each)

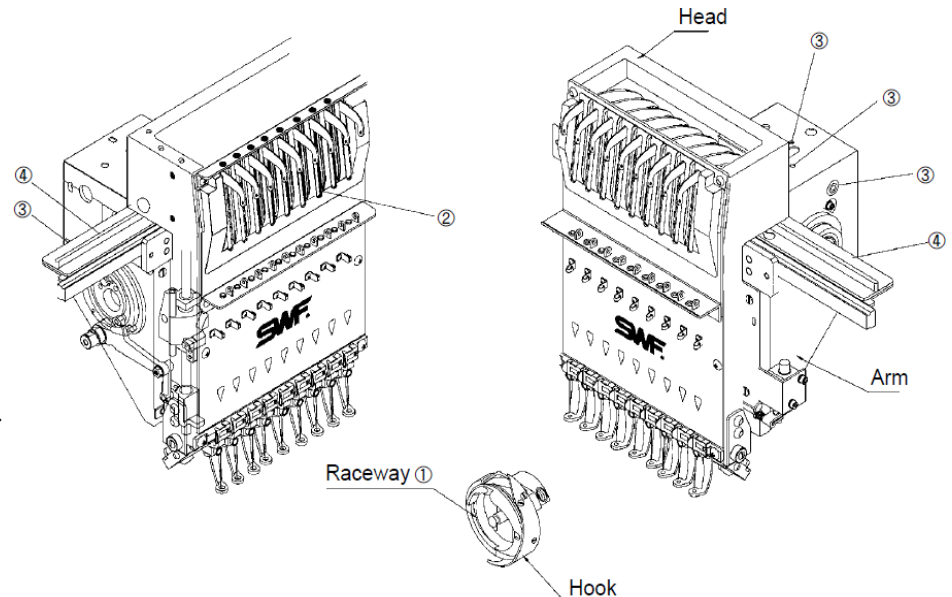


1) Attach the Offset Switch Box specified location and connect Cables.

2) Fix the Cable to Table with Clamp.

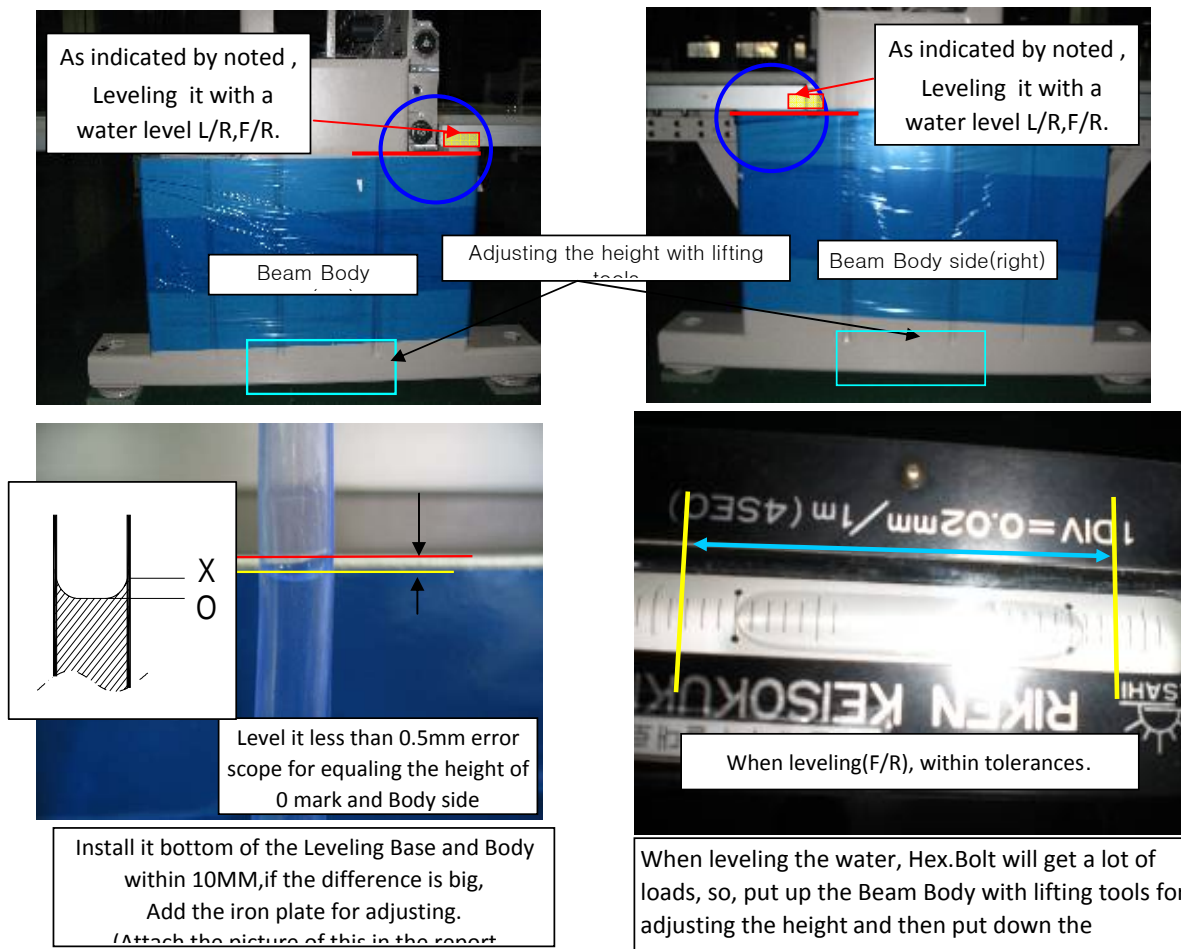
5 Running without Needle

- 1) Oiling the essential part
Arm, Head, Rotary Hook, (Pic 1~4)
- 2) With normal sewing working test design, run the machine at 600 RPM
- 3) Check Point: Bearing Bushing separation, Shaft heat, noise from frame/each belt part.
- 4) Check vibration from machine.
- 5) After finishing Running Test, check status of machine.



6 How to check level status and instal Table Support

- (1) Leveling L/R :With water Hose, adjust less than error scope 0.5mm .
- (2) Leveling F/R :Use error scope 2/100 level (by the central, left and right, within three grid)



※ Variation of needle position from level status of machine may causing the Cutting thread,
So, check throughly and handle it.

Contraction and expansion of Dust Pad may change the levelness,so check it throughly.

(3) How to fix Hex.Bolt

When fixing Hex.Bolt,open Needle Plate from the Head, fix Main Shaft at 201 degree.And then,
put down Needle Bar for inserting Needle Point Jig,check the gap how much jig is inserted to bottom of Needle
Fixed Holder for deciding the amount of Hex.Bolt.



(4) Check Body Support Bolt from Beam Support and fix it. With iron and rubber plate,
adjust the height of Leveling Base.

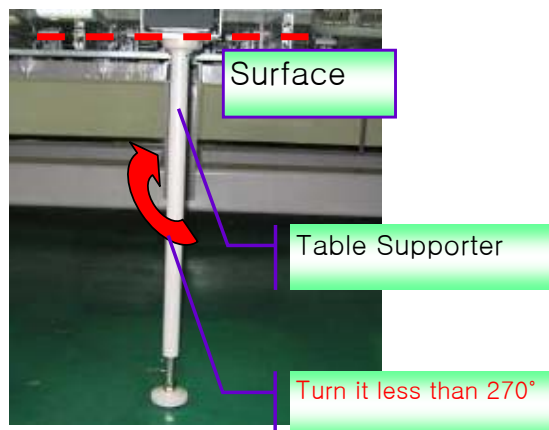
(5) How to install Table Support

1.Connect Table Supporter Bracket to the Table.

2.Insert Table Surpporter to Table Surpporter Bracket

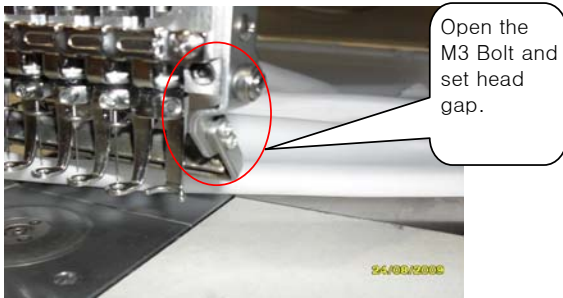
3.When instal the Table Supporter, be cautious of declension and when it's upper part contact to set up
potion, turn it less than 270° and fix it.

4.Connect Table Supporter Nut. (23mm,nut, 2 each)



7 How to check Needle Position and correct.

(1) Check Head gap



- 1) Check F/R gap from No.3 Needle Bar
- 2) Change the Needle Bar by No.1 needle bar
- 3 If F/R gap occurred,with M3 Wrench,set the gap scope under 0.1mm(minimum)

※ If head gap is too much,Cutting Thread and needle broking may occur. If gap is too less,resistance problem will be happened(C/C).So set the machine as minimum gap of it.

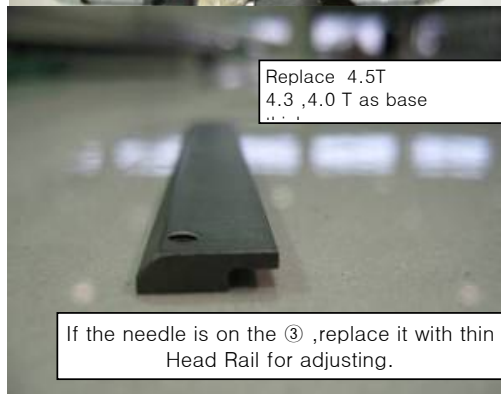
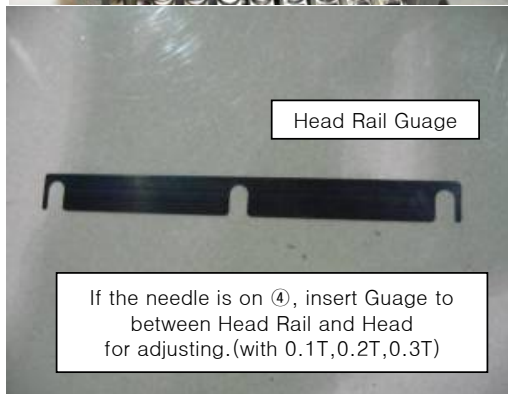
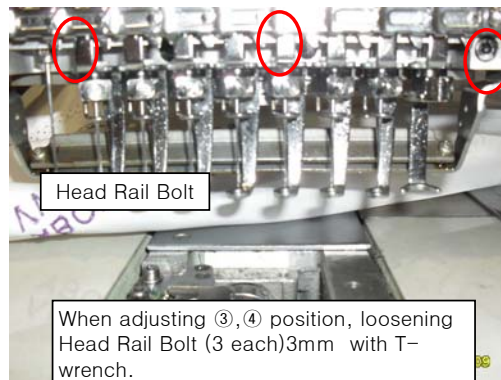
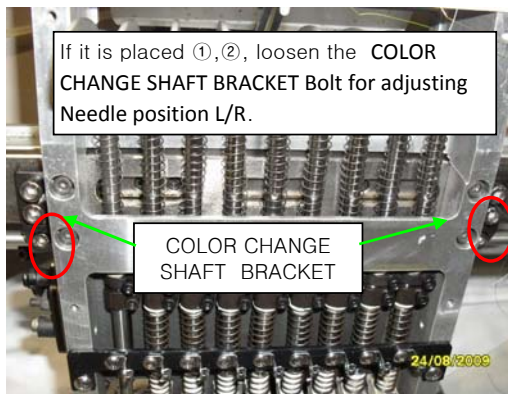
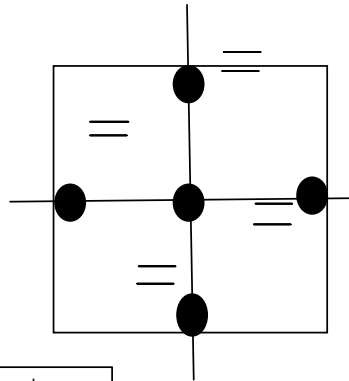
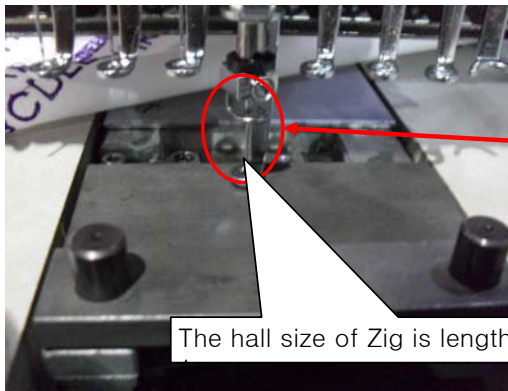
(2) Check Needle Position

- 1) Set the L/R Needle Position first and then F/R after.(with 3mm T Wrench)

If it is on ③ ,change the Head Rail for small one for adjustiong position.

If it is on ④ , insert Gage of B.D.P between Head Rail and Head for adjusting.

- 2)After adjusting,check needle position between No.1 Needle and Last Needle.



8 How to check and reset the Upper Dead /Needle point.

(1) Check Needle Point

Turn the Main Shaft and put down Needle Bar for fixing it as 201 degree.

(2) Insert Needle Point JIG to between Bed Upper Head and bed and then check the gap.

If there is a gap,loosen the Needle Bar Bolt,push and down the Needle Bar for attaching to JIG, Tighten Needle bar Bolt with T-Wrench .Shake JIG Up/Down for checking the gap.



(3) Set Upper Dead Point

1)Fix the main shaft as 0 degree,push Needle Bar and put up the Upper Dead Point Stopper for tightening Bol Grab Upper Dead Point and shake it up/down for checking gap.

If there is a gap, Needle Bar will be stumble.

Don't put up hardly and set for without gap.(When driving, these matters cause noise)

9 How to check Rotary Hook Timing and adjust.

※ Before setting the Rotary Hook, check the Needle twisted or not first, set the Needle forward direction (Optimized Loop forming Condition)

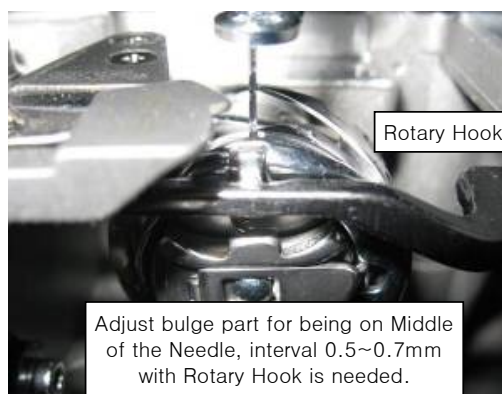
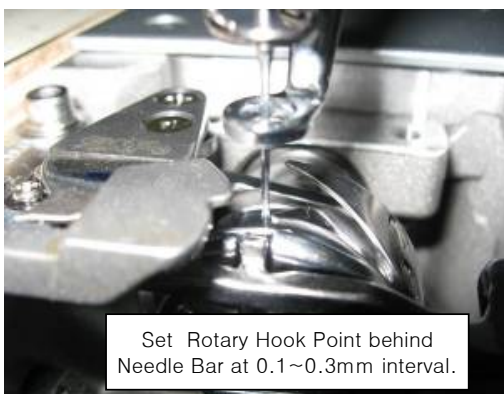
(1) Check/adjust Rotary Hook timing and gap.(with "-" driver)

From the middle Needle Bar , loosen 2(each)screw of Rotary Hook Fixed Screw 3 each(near 135°,75°).

Fix the main Shaft at 201° for checking the Point of Rotary Hook and Needle,gap.

If Point of Rotary Hook is not correct or gap(Needle and Rotary Hook) is big or too small, reset it.

After finish the setting,check First to Last Needle Bar of gap.And then tighten whole Screw.



(2) Check/adjust the position of Rotary Hook.

Adjust bulge part for being on Middle of the Needle, interval 0.5~0.7mm with Rotary Hook is needed ,by loosening Fixed Screw.

10 How to test machine operation and Running Test.

(1) Machine operation TEST.

- 1) Test in/output of design with FDD and USB.(Check the way of formation USB user, FAT format O.K , FAT32 format)
- 2) Test Bar Switch and offset Switch correctly.
- 3) Test Jump Motor movement (Check the 0.3 MM gap of reciprocator and Jump Motor)
by testing Jump movement, check motor,cable,Thread Board,Join Board,SMPS,operation,indirectly.
- 4) Check movement of each Wiper and carry over of blade(wiper),if it is not correct ,reset the Pressure Base.
- 5) By testing for each Picker movement,check Solenoid and position of picker entrance amount.
- 6) Check Upper Thread Holding and Holding equipment amount and adjust it.
- 7) Check Trim Motor movement and Thread Moving Mess movement return position.
- 8) Check Thread Board and related Cables also.
- 9) When driving Frame, check the Table Connecting Cover and interruption and noise.
Check the working range is fit for mechanical specifications. Check position of sensor and adjust it.
- 10)Test movement of Needle Bar Up/Down.(check the status of Jam)

(2) Running Test.

- 1) Driving the machine at 900~1000 RPM (about 1 hour), and then check vibration,heat from
DrivingParts,Frame and other related parts.
- 2) After Running Test, check the status of machine.

11 Sewing TEST.

- ※ Test with thread and fabric from your company and check Status of machine
- ※ Test design your esteemed company.
Write productivity report.Attach the Sample and Design.
- ※When Sewing TEST,train the worker and manager that how to operate/maintain the machine.

Multi Head E,K Report

Country		Model	
Agent		Serial No.	
Company		Version Date	
Date		Technician	

Order	List
1	Check List of Environment before instalation Status of machine before it arrived at your company ☐ Start from Wood box Opening ☐ When you arrived,machine was moving to inside of factory ☐ Arrived during installation ☐ Arrived during assembly (which setp:) ☐ After whole procudre ☐ etc, () (1) Temperature/ humidity,ambience ☐ good ☐ bad (2) The number of layers : (3) Material of bottom : (4) Levelness of floor ☐ good ☐ bad (5) Speculation of voltage : (6) Input 1P (V) Voltage : 3P (R↔S : V) (R↔T : V) (S↔T : V)
2	Check List for installation and exterior (1) Safe Arrival - When arrived, check the levelness of of machine ☐ good ☐ bad - Adjust levelness with Bolt and check (if it is not correct at first) ☐ good ☐ bad (2) Check status of frame and debris - Check status of frame at first site ☐ good ☐ bad - Check debris or not ☐ good ☐ bad
3	Check list for movement TEST and Running TEST After safe arrival,test movement of machine (1) JUMP TEST ☐ good ☐ bad (2) WIPER TEST ☐ good ☐ bad (3) PICKER TEST ☐ good ☐ bad (4) TRIM TEST ☐ good ☐ bad (5) THREAD SENSING TEST ☐ good ☐ bad

4	Check B.D.P status and adjusting																																																																																																																																																																																								
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5	Check list for Hook timing and adjusting(good:O, bad:X)																																																																																																																																																																																								
	Hook timing 201 °, No gapss with Needle, more than 0.3mm,reset it. ① Before ☐ good ☐ bad ② After ☐ good ☐ bad																																																																																																																																																																																								
6	Check list for checking the Pressor Foot and set (good:O, bad:X)																																																																																																																																																																																								
	General Head – If needle bar(180 °) is out of 1.2mm from Upper Face,reset it. ① Before ☐ good ☐ bad ② After ☐ good ☐ bad ※ Able to adjust ,depends on product (delivery Data : 1.2mm, Thin Fabric:0.7mm이하, Thick Fabric:																																																																																																																																																																																								
7	Check list for checking Upper Dead/Needle position and setting																																																																																																																																																																																								
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